

# Work Order ID 50725

July 21, 2009 12:42:18 PM

Page 1

Item ID: D2017-123

Accept

Revision ID: E

Item Name: Step Strut

Start Date: 7/06/09 Start Qty: 2.00

Required Date: 7/06/09 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2017

Rev F

100

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

110

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:15am

OVEN TEMPERATURE:

FINISH TIME:

400F

120

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

(Pb) →

⇒ Sorlosio

(X2)

✗


⇒ 9/09/14

(X2)

✗

BR 09-09-14

(2)

W/O: 50725		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.09.09	90	Punch tube as per Dwg -	SS	09/09/09	2		
		Deburr	M-h	09/09/10	2		

Part No: D2017-123 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 50725

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Item ID: D2017-123

Revision ID: E

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Start Date: 7/06/09 Start Qty: 2.00

Required Date: 7/06/09 Req'd Qty: 2.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 258

0.00



Packaging

Memo

0.00

Packaging

9/9/14 (2x)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/15  
09-9-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Status	Item ID	Rev	Name	Start Date	Quantity	PeJOMp Date	Secrap	ap	Qua	mme	nd	N	C	IECX	li	Sortme	Offse	an	Ty1	Per	Och	to	Vore	Ce	Last	Id	Da
✓	M304TR0.750W.049		304 RD Tube .750...	6/24/09	1.1000	f		100	5	0.0...					1		0	M...							6/3...	6/...	

# Picklist Print

July 22, 2009 12:19:58 PM

Page 1

Work Order ID: 50725

Parent Item: D2017-123RevE

Parent Item Name: Step Strut

Comments:

Start Date: 7/06/09

Required Date: 7/06/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No				f	350.2300	2.2000			



304 RD Tube .750 x .049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

350.2300026

107518 7.27

108498 0

109314 8.5

110113 0.73

110271 0.03

111096 9

111457 11.43

111619 13.2700026

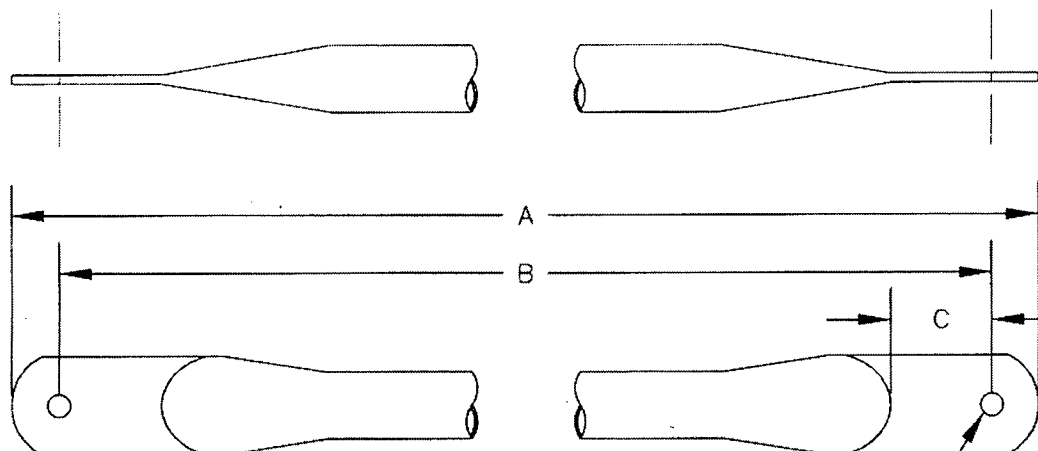
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2.200 09609609 ②

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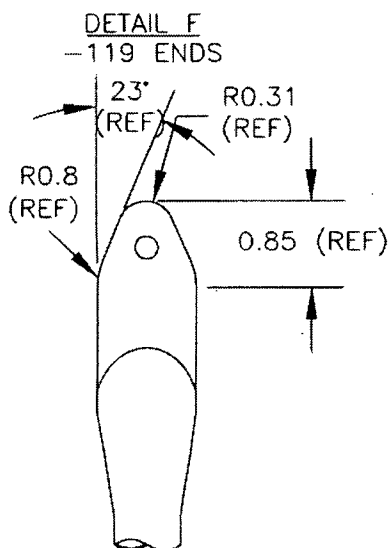
WFO  
50725



PUNCH ENDS PER  
SPEC CTRL D2638  
(-119 SEE NOTE)

"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)  
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)

Part Number	A	B	C	D	E
D2017-101	17.73	16.93	1.30	0.250	0.312
D2017-103	18.74	17.94	1.30	0.250	0.312
D2017-105	14.95	14.15	1.30	0.250	-
D2017-107	15.61	14.81	1.30	0.250	-
D2017-109	13.93	13.13	1.30	0.250	-
D2017-111	15.30	14.50	1.30	0.250	-
D2017-113	20.50	19.70	1.30	0.250	0.312
D2017-115	12.42	11.62	1.30	0.250	-
D2017-117	13.86	13.06	1.30	0.250	-
D2017-119	26.75	25.95	1.30	0.250	-
D2017-121	12.30	11.50	1.30	0.250	-
D2017-123	12.92	12.12	1.30	0.250	-
D2017-125	19.55	18.75	1.30	0.250	-
D2017-127	20.30	19.50	1.30	0.250	-
D2017-129	31.43	30.63	1.30	0.250	-
D2017-131	19.68	18.88	1.30	0.250	-
D2017-133	30.66	29.86	1.13	0.250	-



NOTE:

FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)  
BEND FLARED ENDS 8" UP/ 8" DOWN

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

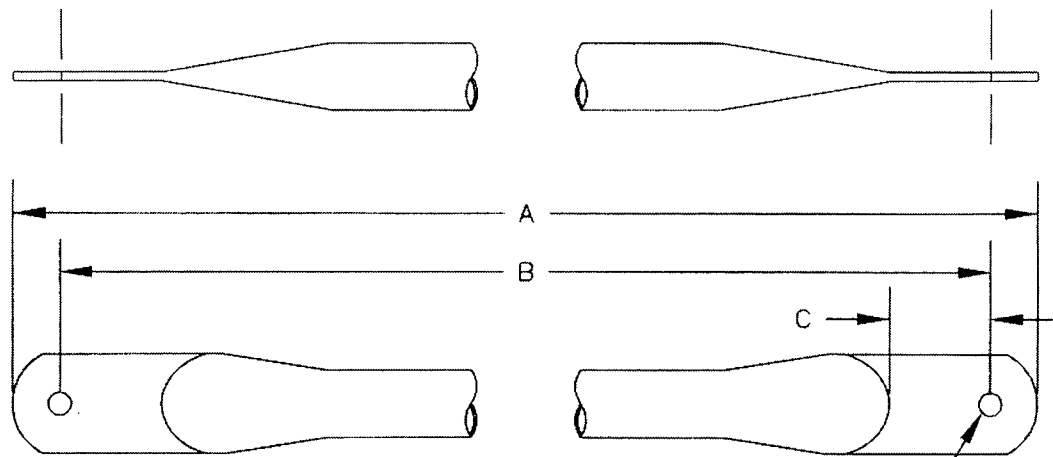
DESIGN BW	DATE 99.04.16	CHECKED <i>WE</i>	APPROVED <i>WE</i>	DRAWING NO. D2017	REV. E
PART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				SHEET 1 OF 2	
E	99.04.16	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897)		SCALE N1S	
D	96.03.28	ADD PARTS			
C	95.01.26	ADDED PARTS			

**DART**



RELEASED  
DATE: 04.04.16  
BY: KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW	1	DRAWING NO.	REV. E
CHECKED KE	APPROVED [Signature]	D2017	SHEET 2 OF 2
DATE 99.04.16	TITLE STEP STRUTS	SCALE NTS	



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

50725

Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

NOTE:  
MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: POLISHED (SAT. W/100 (435 L) PER PART SPEC (435 L)